

Shp July 15 OK Scanner

Work Order ID 70514



Page 1

Friday, June 10, 2011 11:22:46 AM

Item ID: D2801-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment RH, Folding

Start Date: 6/10/2011 Start Qty: 1.00



Cust-Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Signature]

Date: 11-06-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2801

Rev A1

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622 extrusion to 86.15" long as per Dwg D2801
2-Debur and bevel ends for welding

AE 11.06.21.

(X)

0

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/16/15

(cc)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Large Fab

Large Fab

0.00

Memo

0.00

1-Weld arms and end caps as per Dwg D2801 & QSI 004. Inspect for foreign objects as per QSI 024.

A/R ☐ Aluminum Rod ☐ M114703
M117884

2-Grind end cap welds flush as per Dwg D2801

11.07.05

140



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

1 0 BEN/07/05

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Subtotal

4 RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date:	6/10/2011	Start Qty:	1.00	Cust Item ID:		
Required Date:	6/15/2011	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00				1	0		
165  QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00					1		
170  Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00				1	0		
Large Fab	1-Deburr and bevel aft end for welding.								
	2-Weld as per Dwg d2801 a/r AL ROD Batch: <u>M114703</u>								
	3-Grind end cap welds flush as per dwg D2801								

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Start Date:	6/10/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	6/15/2011	Req'd Qty:	1.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 QC Quality Control	QC9 Inspect visual per QSI004- Fusion Welds QC40 5 Memo	0.00 0.00							Pro 7
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
200 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo And chemical conversion coat as per QSI005 4.1	0.00 0.00							1 BL 11-7-8

Dart Aerospace Ltd

W/O: 70514		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/7/11	#160	change step to 240	BE	11.07.11			S 11/6/11

Part No: D2801-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date:	6/15/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat								
	Powder Coating								
<div> <div>M 117745</div> <div> <div>7:30</div> <div>START TIME: 3:20</div> <div>OVEN TEMPERATURE: 320</div> <div>FINISH TIME: 8:00</div> </div> <div>117863</div> </div>									
220	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
	HandFinish								
	Hand Finishing								
230	QC3- Inspect Part Finish	0.00							
	QC								
	Quality Control								

1A 11/07/11

1 BL 11-7-11

1 11/07/11

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Work Order ID 70514

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Stop



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Start Date: 6/10/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-014 Location: _____ PPP Rev: _____								
300 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

ME 11-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

* Friday, June 10, 2011 11:22:56 AM

Page 1

Work Order ID: 70514

Parent Item: D2801-042

Parent Item Name: Step Weldment RH, Folding







Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-06-10 JLM VERIFIED BY:LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C  Step Extrusion		Manufactured	No				Each	35.7000		 1 A.E 11.06.21.			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				HALL			6						
				64409			6						
				WA			29.7						
				46910			2						
				66970			27.7						
D2734  Step End Plate		Manufactured	No				Each	48.0000		 1 11.07.05			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				WA			45						
				69537			45						
				WA015			3						
				66143			3						
D2802-2  Arm		Manufactured	No				Each	1.0000		 2 11.07.05			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST141			1						
				370719			1						
				35597			1						

WA 68293 (H)

11.07.05

11.07.05

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

Friday, June 10, 2011 11:22:56 AM

Work Order ID: 70514



Parent Item: D2801-042



Parent Item Name: Step Weldment RH, Folding

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 1.00

Required Qty: 1.00

D2734

Manufactured No

Each

48.0000

1



Step End Plate

11.07.06

Location

Loc Qty

Loc Code

WA

45

69537

45

WA015

3

66143

3

1

Friday, June 10, 2011 11:22:56 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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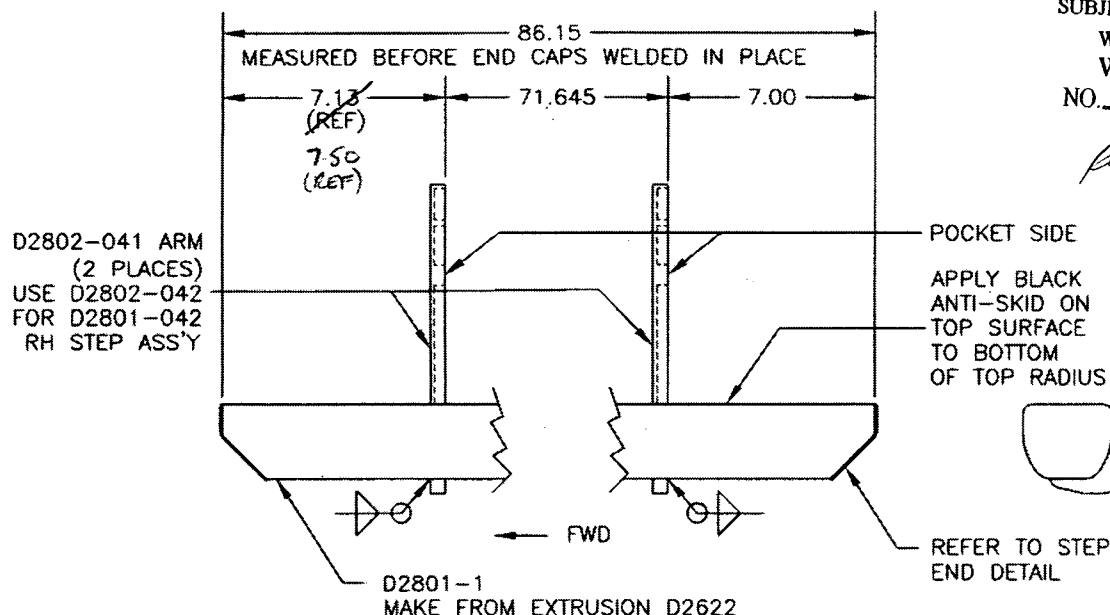
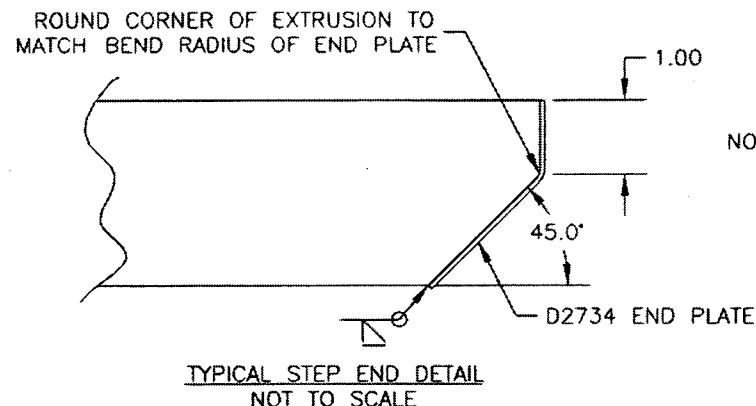
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2801	SHEET 1 OF 1
DATE 00.11.03	00.11.03	TITLE STEP WELDMENT	SCALE NTS
A1	A	NEW ISSUE	
		7.50 WTS 7.13	

RELEASED
00.11.13

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *70514*
211-06-10



D2801-041 LH STEP ASSEMBLY (SHOWN)
D2801-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

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